

Work Order ID 69940 - 2

Tuesday, May 24, 2011 2:28:05 PM

Page 1

Item ID: K642-512

Revision ID:

Item Name: saddle kit 642-512

Start Date: 5/24/2011 Start Qty: 4.00

Required Date: 5/31/2011 Req'd Qty: 4.00

Reference:

Accept

Cust Item ID:

Customer:

Setup Start

Stop

Run Start

Stop

Approvals:

Process Plan:

QC:

Date: 11-05-24

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

DSI 9467

Rev A

IIN D206-642

Rev N

100



DC

Document Control

DOCUMENT CONTROL

0.00

Memo

0.00

Create White labels per PPP K642-512 CHG004

Subtotal

110



Packaging

Packaging

Pick Kit

0.00

Memo

0.00

11/8/15 24 sf

Work Order ID 69940

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Page 2

Item ID: K642-512

Accept

Revision ID:

Item Name: saddle kit 642-512

Setup Start

Stop

Start Date: 5/24/2011 Start Qty: 4.00

Required Date: 5/31/2011 Req'd Qty: 4.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC4- 100% Inspect kits for completeness

0.00

8/10/12

(+2)

QC

Memo

Quality Control

130

Packaging

0.00

DK

11/12/25 (2)

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP K642-512 Location: A

140

QC21- Final Inspection - Work Order Release

0.00

11/18/25 (2)

QC

Memo

0.00

Quality Control

11/10/125

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Page 1

Work Order ID: 69940

Parent Item: K642-512

Parent Item Name: saddle kit 642-512



Start Date: 5/24/2011

Required Date: 5/31/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A 05.06.07 new issue EC
IPP Rev.B 05.02.08, Per ECN1080P

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN3C35A 		Purchased	No			110	Each	87.0000	3	12			
BOLT													

Location	Loc Qty	Loc Code
FG	4	
18914	4	
ST352	20	
117366	20	
ST353	63	
114523	30	
116082	3	
116924	30	

AN3C36A

Purchased No

110 Each 157.0000

9 36

Location	Loc Qty	Loc Code
FG	14	
101261	4	
116590	10	
FP-B	47	
111925	47	
ST303	8	
116590	8	
ST353	88	
117125	88	

11/7/12 11/8/15

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Work Order ID: 69940

Parent Item: K642-512

Parent Item Name: saddle kit 642-512



Start Date: 5/24/2011

Required Date: 5/31/2011

Start Qty: 4.00

Required Qty: 4.00

AN3C41A



BOLT

Purchased

No.

110

Each

140.0000

8

32



162
M117950

162

Location

Loc Qty

Loc Code

FG

4

103324

4

ST354

136

117163

56

117407

80

AN4C6A



Bolt

Purchased

No.

110

Each

407.0000

12

48



11/8/15 SP

210

Location

Loc Qty

Loc Code

FG

4

103344

4

ST306

50

117313

50

ST356

353

116003

3

116400

50

116704

100

~~117610~~

150

~~117794~~

50

11/8/15 SP

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Work Order ID: 69940

Parent Item: K642-512

Parent Item Name: saddle kit 642-512

Start Date: 5/24/2011

Required Date: 5/31/2011

Start Qty: 4.00

Required Qty: 4.00

AN5C11A



Bolt

Purchased

No

110

Each

160.0000

8

32



Location

Loc Qty

Loc Code

FG

4

104817

4

ST338

156

116075

26

116381

50

117094

80

110

Each

105.0000

4

16



AN5C12A



BOLT

Purchased

No

Location

Loc Qty

Loc Code

FG

2

18918

2

ST338

103

116075

3

117313

100

110

Each

122.0000

4

16



AN5C13A



BOLT

Purchased

No

Location

Loc Qty

Loc Code

FG

4

18918

4

MEZZ

68

116075

68

ST338

50

117313

50

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Work Order ID: 69940

Parent Item: K642-512

Parent Item Name: saddle kit 642-512

Start Date: 5/24/2011

Required Date: 5/31/2011

Start Qty: 4.00

Required Qty: 4.00

AN5C15A



Bolt

Purchased

No

110

Each

54.0000

1

4



sf

Location

Loc Qty

Loc Code

ST339

54

111819

29

117764

25

Purchased

No

110

Each

110.0000

2

8



sf

Location

Loc Qty

Loc Code

FG

4

18918

4

ST340

106

113164

31

116380

50

117407

25

Purchased

No

110

Each

65.0000

2

8



11/8/11 sf

Location

Loc Qty

Loc Code

FG

2

18918

2

ST340

63

112454

38

117763

25

8

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Work Order ID: 69940

Parent Item: K642-512

Parent Item Name: saddle kit 642-512



Start Date: 5/24/2011

Required Date: 5/31/2011

Start Qty: 4.00

Required Qty: 4.00

AN5C35A

Purchased

No

110

Each

58.0000

1 4



Location

Loc Qty

Loc Code

ST340

58

108084

12

108407

46

AN960C10L

NAS1149C0332
R

Purchased

No

110

Each

0.0000

24 96



washer

AN960C416L

Purchased

No

110

Each

0.0000

24 96



WASHER

AN960C516L

NAS1149C0532
R

Purchased

No

110

Each

0.0000

8 32



WASHER

D206-648-013

Manufactured

No

110

Each

10.0000

1 4



GHW Modification

Location

Loc Qty

Loc Code

FG120

10

67596

6

68347

4

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W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 69940

Parent Item: K642-512

Parent Item Name: saddle kit 642-512

Start Date: 5/24/2011

Required Date: 5/31/2011

Start Qty: 4.00

Required Qty: 4.00

D2652

Manufactured No

110 Each

424.0000

16

64 18x

(462)



Brushing



B71573

B71833

SP

Location

Loc Qty

Loc Code

FG

44

31985

44

ST019

380

67756

180

68941

200

D2712

Manufactured No

110 Each

451.0000

10

40

(19)



Set Screw



B71160

SP

Location

Loc Qty

Loc Code

FG

50

29962

50

ST012

252

66955

252

ST021

149

65115

149

D2932-2

Manufactured No

110 Each

5.0000

1

4



Saddle RH Out, 206



B69924

11/8/11 SP

(19)

Location

Loc Qty

Loc Code

ST421

5

66381

1

67253

4

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Work Order ID: 69940

Parent Item: K642-512

Parent Item Name: saddle kit 642-512

Start Date: 5/24/2011

Required Date: 5/31/2011

Start Qty: 4.00

Required Qty: 4.00

D2933-2

Manufactured No

110 Each 4.0000



Saddle RH In, 206

1 4 (3x) B69921 B70876

Location

Loc Qty

Loc Code

ST421

4

67254

4

Manufactured No

110 Each 38.0000

D2934



Saddle Spacer

2 8 B70772

Location

Loc Qty

Loc Code

FG

6

31929

6

ST027

32

67585

32

Manufactured No

110 Each 56.0000

D2935



Saddle Spacer

2 8 B70770

Location

Loc Qty

Loc Code

ST027

56

66564

56

Manufactured No

110 Each 4.0000

D2938-2



Saddle RH Out, 206

1 4 (2) B69925 11/8/15 B71074 (2) SP 11/24

Location

Loc Qty

Loc Code

ST421

4

67255

4

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID: 69940

Parent Item: K642-512

Parent Item Name: saddle kit 642-512

Start Date: 5/24/2011

Required Date: 5/31/2011

Start Qty: 4.00

Required Qty: 4.00

D2939-2

Manufactured No

110 Each

4.0000

1 4 (32)



Saddle RH In, 206

B69919

B70877

Location

Loc Qty

Loc Code

ST421

4

67256

4

Manufactured No

110 Each

47.0000

2 8 (32)

D3396-3



Spacer

B70983

Location

Loc Qty

Loc Code

FG

10

26772

10

ST052

37

66488

37

Manufactured No

110 Each

19.0000

1 4 (1)

D3407-043



Tow Ring

B69540

Location

Loc Qty

Loc Code

ST420

2

66386

2

ST464

17

64071

7

68339

10

B72692

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID: 69940

Parent Item: K642-512

Parent Item Name: saddle kit 642-512

Start Date: 5/24/2011

Required Date: 5/31/2011

Start Qty: 4.00

Required Qty: 4.00

D3456-1

Manufactured No

110 Each

71.0000

1

4



Washer



B71033

Location

Loc Qty

Loc Code

FG

7

25701

7

ST054

64

63239

4

66848

6

68748

54

D3457-1

Manufactured No

110 Each

40.0000

2

8



Washer



B7077

B71849

Location

Loc Qty

Loc Code

FG

10

32409

10

ST054

30

67779

30

D3672-1

Manufactured No

110 Each

1,350.000

24

96



Phenolic Washer



Location

Loc Qty

Loc Code

ST074

1350

64177

850

66821

500

D3672-3

Manufactured No

110 Each

695.0000

24

96



Phenolic Washer



B7115911015

Location

Loc Qty

Loc Code

ST074

695

64176

695

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID: 69940

Parent Item: K642-512

Parent Item Name: saddle kit 642-512



Start Date: 5/24/2011

Required Date: 5/31/2011

Start Qty: 4.00

Required Qty: 4.00

D3672-7



Phenolic Washer

Manufactured No

110 Each

994.0000

24

96



Location

Loc Qty

Loc Code

ST074

994

53237

244

64175

750

Purchased

No

110 Each

608.0000

20

80



m118077 f

MS21043-3



Nut

Location

Loc Qty

Loc Code

FG

80

103691

80

ST301

528

112314

528

Purchased

No

110 Each

1,670.000

13

52



m118379 4/8/15 sf (4)

MS21043-4



Nut

Location

Loc Qty

Loc Code

FG

40

104603

40

ST300

576

117423

576

ST301

1054

115936

40

116549

14

117601

500

117793

500

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID: 69940

Parent Item: K642-512

Parent Item Name: saddle kit 642-512



Start Date: 5/24/2011

Required Date: 5/31/2011

Start Qty: 4.00

Required Qty: 4.00

MS21043-5



Purchased

No

110

Each

535.0000

4

16



SP 11/8/15



Location

Loc Qty

Loc Code

FG

20

101418

20

ST301

515

112314

415

116548

100

16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

4.7 206L/L-1/L-3/L-4/407 HIGH GEAR FLOAT SKIDTUBES (TRI-BAG COMPATIBLE)

Item	Qty -511	Qty -512	Qty -541	Qty -547	Qty -013	Part Number	Description
	X					D206-642-511	SKIDTUBE INSTALLATION, LH
		X				D206-642-512	SKIDTUBE INSTALLATION, RH
	1	1	X			D206-642-541	SKIDTUBE
				X		D206-642-547	WEARSHOE KIT (REPLACES -543 KIT)
	1	1			X	D206-648-013	GROUND HANDLING KIT
1			1			D3274-041	SKIDTUBE ASSEMBLY
3			1			D2646	* AFT CAP ⁽¹⁾
4			2			AN3C4A	* BOLT ⁽¹⁾
5A			2			AN960C10L	* WASHER ⁽¹⁾
5B			2			D3672-1	* WASHER (REPLACES NAS1515H3L) ⁽¹⁾
6	1					D2932-1	SADDLE, FWD OUT, LH
6		1				D2932-2	SADDLE, FWD OUT, RH
7	1					D2933-1	SADDLE, FWD IN, LH
7		1				D2933-2	SADDLE, FWD IN, RH
8	1					D2938-1	SADDLE, AFT OUT, LH
8		1				D2938-2	SADDLE, AFT OUT, RH
9	1					D2939-1	SADDLE, AFT IN, LH
9		1				D2939-2	SADDLE, AFT IN, RH
10	8	8				AN3C41A	BOLT
11	16	16				D2652	BUSHING
12A	8	8				MS21043-3	NUT
12B	16	16				D3672-7	WASHER (REPLACES NAS1515H5)
13	4	4				AN5C11A (or AN5C12A)	* BOLT ⁽²⁾
14	4	4				AN5C11A (or AN5C13A)	* BOLT ⁽²⁾
15A	8	8				AN960C516L	WASHER
15B	8	8				D3672-7	WASHER (REPLACES NAS1515H5L)
16	12	12				AN4C6A	BOLT
17A	24	24				D3672-3	WASHER (REPLACES NAS1515H4L)
17B	24	24				AN960C416L	WASHER
18	12	12				MS21043-4	NUT
20A			9	9		D3537-1	* WEARPAD ⁽¹⁾ (REPLACES D2648-3)
21A			1	1		D3537-3	* WEARPAD ⁽¹⁾ (REPLACES D3429-1)
22A			1	1		D3535-15	* WEARSHOE ⁽¹⁾ (REPLACES D2656-15)
22B			1	1		D3536-15	* GASKET ⁽¹⁾
23A			1	1		D3535-23	* WEARSHOE ⁽¹⁾ (REPLACES D2656-23)
23B			1	1		D3536-23	* GASKET ⁽¹⁾
24A			1	1		D3535-39	* WEARSHOE ⁽¹⁾ (REPLACES D3287-1)
24B			1	1		D3536-39	* GASKET ⁽¹⁾
25A			1	1		D3535-35	* WEARSHOE ⁽¹⁾ (REPLACES D2656-35)
25B			1	1		D3536-35	* GASKET ⁽¹⁾
26A			78	78		AN3C4A	* BOLT ⁽¹⁾
26B			78	78		AN960C10L	* WASHER ⁽¹⁾
26C			78			ALS7-1032-130	* INSERT ⁽¹⁾ (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
30	1	1				D3407-043	TOW RING
32A	1	1				D3456-1	WASHER
32B	2	2				D3457-1	WASHER
33	1	1				MS21043-4	NUT
34			1			AN4C5A	BOLT
35			1			AN960C416	WASHER
36			1			D3413-1	RING
37	10	10				D2712	SET SCREW
38	2	2				D2934	SADDLE SPACER
39	2	2				D2935	SADDLE SPACER

continued on next page...

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Date: 09.09.09

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ITEM	QTY -511	QTY -512	QTY -541	QTY -547	QTY -013	PART NUMBER	DESCRIPTION
40					2	D3414-041	LUG ASSEMBLY (GHW)
41					4	AN3C37A	BOLT
42					8	D2652	BUSHING
43					4	MS21043-3	NUT
44					4	AN960C10	WASHER
50	9	9				AN3C36A	BOLT
51	3	3				AN3C35A	BOLT
52	24	24				AN960C10L	WASHER
53	24	24				D3672-1	WASHER (REPLACES NAS1515H3L)
54	12	12				MS21043-3	NUT
55	2	2				D3396-3	SPACER
56A	1	1				AN5C35A	BOLT
56B	1	1				AN5C15A	BOLT
60	2	2				AN5C32A	BOLT
61	2	2				AN5C34A	BOLT
62	4	4				MS21043-5	NUT

NOTES: ⁽¹⁾ DENOTES THAT PART IS INCLUDED WITH D3274-041 ASSEMBLY ABOVE⁽²⁾ CHOICE OF BOLT WILL DEPEND ON CROSSTUBE (SEE INSTALLATION PROCEDURE)